

Date: Wednesday, 2/20/2008 4:23:43 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HANDLE WELDMENT
Job Number : 37546	
Estimate Number : 10333	
P.O. Number : 1	Part Number : D2530
This Issue : 2/20/2008 S.O. No. :	Drawing Number : D2530 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 1 /	Drawing Revision : B
Previous Run : 36657	Material :
Written By :	Due Date : 3/10/2008 Qty: 20 Um: Each
Checked & Approved By : <u>08 02 21</u>	
Comment : Est Rev:E Removed Purchasing 05-11-07 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304TR0750W049	304 RD Tube .750 x .049W
-----	----------------	--------------------------



Comment: Qty.: 3.0602 f(s)/Unit Total : 61.2045 f(s)

Material: 304/316 SS Seamless Tubing 0.75" OD x 0.049" wall(M304TR0.750W.049)

Batch: M107099 (3x) M107098 (7x)

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut to length as per Dwg D2536

2-Deburr

CB 08/03/10 (20)

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

08/03/10 (20)

4.0	D2534	Lock Plate
-----	-------	------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

QTY	Part #	Description	Batch
2	D2534	Lock Plate	<u>637563</u>

08/04/07

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301 ✓

2-Deburr ✓

08/04/07 20x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:23:43 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE WELDMENT

Job Number: 37546

Part Number: D2530

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/04/08 (20)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/08 (20)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

08-04-08

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/04/08 (20)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST204

08/04/08 (20)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/09

Job Completion



MF

08-04-08.

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



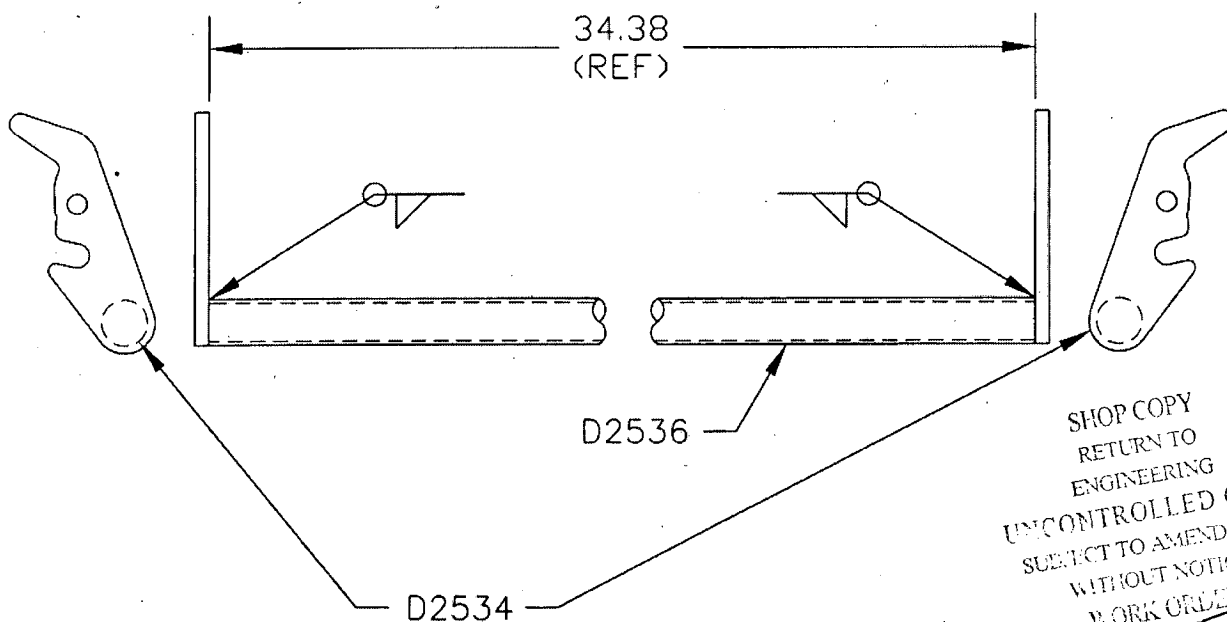
DESIGN B WILLIAMS	DRAWN BY PH	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2530	REV. B SHEET 1 OF 1
DATE 04.12.14		TITLE HANDLE WELDMENT	
A	96.06.18	NEW ISSUE	
B	04.12.14	UPDATE NOTES AND DIMENSIONS	

RELEASED

04.12.16 #

PART LIST -- D2530

QTY	PART NUMBER	DESCRIPTION
X	D2530	HANDLE WELDMENT
1	D2536	HANDLE
2	D2534	LOCK PLATE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37546

D2530 HANDLE WELDMENT

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

— 1714